



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D2580-1**

**Job Sheet 170323**



**Part No:** D2580-1

**Job Qty:** 4 ea

**Part Name:** 205 Bent Tube



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** High

**Job Created:** 1/15/18

**Job Tracking No:**

**Due Date:** 1/19/18

**Created By:** Jason Leroux

**Type:** SOLD

**Description:**

**Note:** DWG REV G SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01 as per DEO D1 DD ver:ec

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 4 Ea  | 1/18/18    | 1/18/18  | 0.00      | 0.00    | Start Up Skid tubes   |           |          |
| 100   | Skid tubes         | 4 pcs | 1/18/18    | 1/18/18  | 0.00      | 3.70    | Skid tubes            |           |          |
| 101   | QC                 | 4 pcs | 1/18/18    | 1/18/18  | 0.00      | 0.00    | QC6 5                 |           |          |
| 110   | HandFinish         | 4 pcs | 1/18/18    | 1/18/18  | 0.00      | 1.67    | HandFinish1           |           |          |
| 120   | QC                 | 4 pcs | 1/18/18    | 1/18/18  | 0.00      | 0.00    | QC7                   |           |          |
| 125   | Skid tubes         | 4 pcs | 1/19/18    | 1/19/18  | 0.00      | 3.70    | Skid tubes            |           |          |
| 130   | QC                 | 4 pcs | 1/19/18    | 1/19/18  | 0.00      | 0.00    | QC5                   |           |          |
| 140   | Packaging          | 4 pcs | 1/19/18    | 1/19/18  | 0.00      | 0.00    | Packaging3            |           |          |
| 150   | QC21-SA            | 4 Ea  | 1/19/18    | 1/19/18  | 0.00      | 0.00    | QC21                  |           |          |

Part Op 100 - 1- Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D 3-Open holes to 0.508  
Descriptions: as per Dwg D2580 4-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube test fit inspection saddles on FWD & AFT saddle holes using DT9916.

125 - 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: M138654 Sikaflex expire date: 2018-04-21 Start time and date: January 31st bond for 12hrs

140 - LOCATION : LG002

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D2500-1-190    | 4        | 136       | 0         | 0       |
|                       | D2596          | 4        | 0         | 0         | 0       |

### Part Specifications

Specifications could not be found.

Plex 1/15/18 9:01 AM dart.leroux.jason

**DART**  
AEROSPACE  
**S036696**

**Dart Aerospace Ltd.**

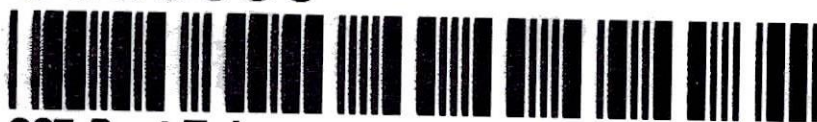
1270 Aberdeen Street  
Hawkesbury, ON K64 1K7

CANADA

TEL.: 1 613 632-5200

Email: [sales@dartaero.com](mailto:sales@dartaero.com)

[www.dartaerospace.com](http://www.dartaerospace.com)



**205 Bent Tube**

**PART NO: D2580 - 1**

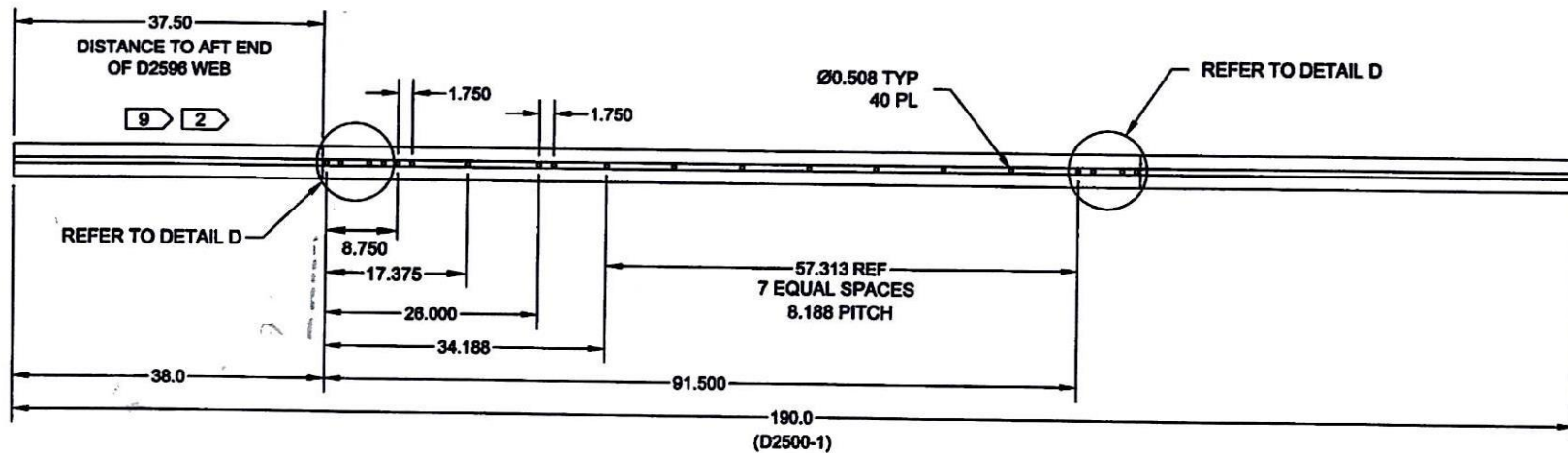
**Original Serial #: S036696**

**Revision:**

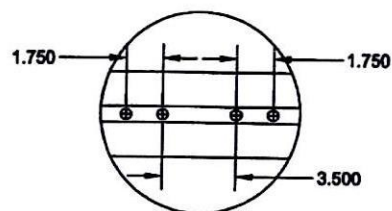
**Operation: Start up Operation 01/29/18**

**Change No:**

**Job No: 170323**



**D2580-101 TUBE**



**DETAIL D**  
SCALE 5X

**RELEASED**

2017 JUL 05

|            |                    |                                                                                                                                                                                                                                                                                       |              |
|------------|--------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | DS                 | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                             |              |
| DRAWN      | SAD                | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                           |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.                                                                                                                                                                                                                                                                           | REV. H       |
| MFG. APPR. | <i>[Signature]</i> | D2580                                                                                                                                                                                                                                                                                 | SHEET 9 OF 9 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                                 | SCALE        |
| DE APPR.   | <i>[Signature]</i> | 205 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                 | NTS          |
| DATE       | 17.06.09           | <small>COPYRIGHT © 1998 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |

8 7 6 5 4 3 2 1